

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021692**Date Inspected:** 12-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # SEGMENT12AE

This QA observed ZPMC qualified welding personnel identified as 067752 perform Shielded Metal Arc Welding (SMAW) Process on weld joint CA6501-001. ZPMC Quality Control Personnel (QC) identified as Mr. Wang li yang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-TC-U4b-FCM-1.

This QA observed ZPMC qualified welding personnel identified as 067752 perform Shielded Metal Arc Welding (SMAW) Process on weld joint CA3001-005. ZPMC Quality Control Personnel (QC) identified as Mr. Wang li yang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-TC-U4b-FCM-1.

OBG # SEGMENT12CE

This QA observed ZPMC qualified welding personnel identified as 040378 perform Shielded Metal Arc Welding (SMAW) Process on weld joint CA3005E-269. ZPMC Quality Control Personnel (QC) identified as Mr. Wang li

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

yang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2112-FCM-1.

OBG # SEGMENT12CW

This QA observed ZPMC qualified welding personnel identified as 057333 perform Shielded Metal Arc Welding (SMAW) Process on weld joint CA3010E-081. ZPMC Quality Control Personnel (QC) identified as Mr. Zhou peng was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2112-FCM-1.

OBG # SEGMENT12BE

This QA observed ZPMC qualified welding personnel identified as 040367 perform Flux Cored Arc Welding (FCAW) Process repair welding on weld joint SEG3002M-090. ZPMC Quality Control Personnel (QC) identified as Mr. Wang li yang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-2G (2F)-ESAB-Repair and Weld Repair Report B-WR20266.

This QA observed ZPMC qualified welding personnel identified as 040367 perform Flux Cored Arc Welding (FCAW) Process repair welding on weld joint SEG3002N-090. ZPMC Quality Control Personnel (QC) identified as Mr. Wang li yang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-2G (2F)-ESAB-Repair and Weld Repair Report B-WR20266.

This QA observed ZPMC qualified welding personnel identified as 040367 perform Flux Cored Arc Welding (FCAW) Process repair welding on weld joint SEG3003S-035. ZPMC Quality Control Personnel (QC) identified as Mr. Wang li yang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-2G (2F)-ESAB-Repair and Weld Repair Report B-WR20266.

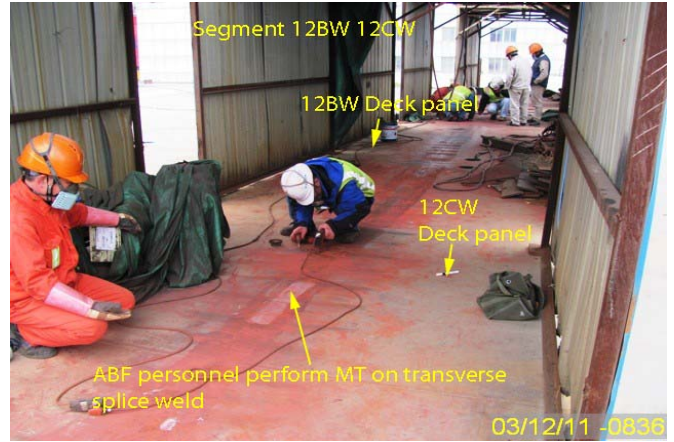
OBG # SEGMENT 12BW 12CW

This QA observed that ABF personnel perform MT on Deck panel transverse splice welds. See attached photos.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

As mention above

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-00422372, who represents the Office of Structural Materials for your project.

Inspected By: Sukanthan,Dhanasingh

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer